

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026800**Date Inspected:** 01-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA

CWI Name:	Chris Concha		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** Maintenance Travelers**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

Revised Brake Mounts (Mock-up)

This QA Inspector randomly observed WMI production welder Mr. Richard Fuentes WID #3201 and one helper, performing layout, fitting and tack welding ASTM A572 Gr. 50, material 1" in thickness to trolley links suspension plates 2B and 3B for the Traveler Revised Brake Mounts (Mock-up). This QA Inspector observed Mr. Fuentes performing tack welding using approved Flux Core Arc Welding (FCAW) activities in all positions randomly throughout the shift.

This QA Inspector randomly observed WMI production welder Mr. Mike Ruiz (WID # 3155) welding 5/8" fillet weld joining ASTM A572 Gr. 50, material 1" in thickness to trolley links suspension plates 2B and 3B for the Traveler Revised Brake Mounts (Mock-up). This QA Inspector observed Mr. Ruiz performing Flux Core Arc Welding (FCAW) activities in the horizontal position (2F) randomly throughout the shift.

SAS WB Traveler

This QA Inspector randomly observed Smith Emery, CWI, QC Inspector Mr. Chris Concha performing visual inspection on the SAS WB traveler. Mr. Concha informed this QA Inspector that he had found several areas for in process grinding and welding. This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) grinding and welding areas found Mr. Concha using Flux Core Arc Welding (FCAW) process in all

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positions on tube steel and plate material, randomly throughout the shift. QC visual inspection and pick-up welding not completed on this date.

RPI Coating (Blast and Paint)

This QA Inspector performed random shop observations and observed that RPI Coating is on site to continue with coating application on the Elevating Platforms and Bike Path Traveler Assemblies. QA Inspector was informed by RPI Coating Quality Control (QC) Representative Mr. Preston Keen that RPI is going to touch top coating on the using the Sherwin Williams Polysiloxane XLE-80 today on three (3) elevating platforms and bike path assemblies. Later in the morning this QA Inspector randomly observed that RPI personnel performing touch up on the top coating application, using the Sherwin Williams Polysiloxane XLE-80 on the above mentioned material. QA noted that touch-up on the Bike Assemblies not completed on this date.



Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910 , who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
